

Work Order ID 67675

Tuesday, March 29, 2011 11:15:34 AM



Page 1

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 3/29/2011

Start Qty: 600 *mf*

Cust Item ID:

Required Date: 4/1/2011

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *M*Date: *11-03-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654 ☐ 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 ☐ 3-Using the uni-bit, open holes to finish size as per Dwg D2654 ☐ 4-Debur holes and ends

> DP 11-4-07 (6)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S. S. S. S. S.

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

*11-4-8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67675

Tuesday, March 29, 2011 11:15:34 AM



Page 2

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 3/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 BE11/04/08

140

Identify as per dwg & Stock Location: 46

0.00



Packaging

Memo

0.00

Packaging

DP 11-4-8 6

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 MF 11-04-11

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:15:40 AM

Page 1

Work Order ID: 67675

Parent Item: D2654-5

Parent Item Name: Web




Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140 		Manufactured	No			100	Each	30.0000	1	2			

EXT. "I BEAM" THICK

Location

LG

41591

Loc Qty

30

30

Loc Code

⑥ — NP 11-47

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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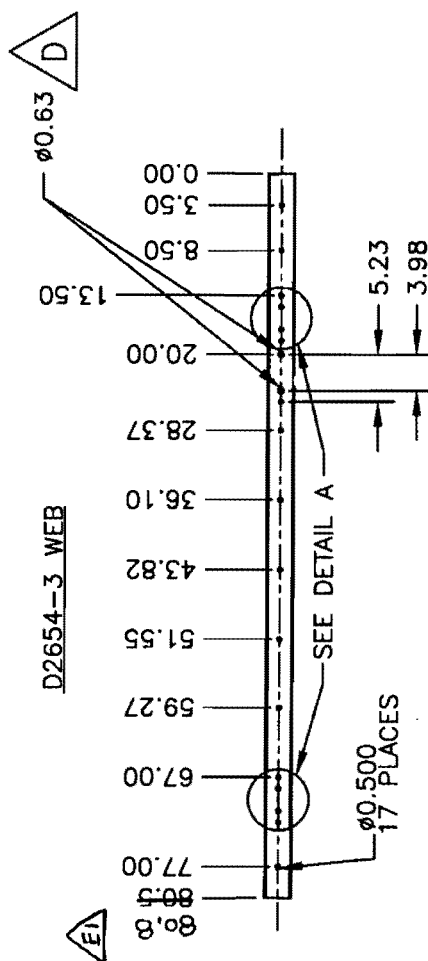
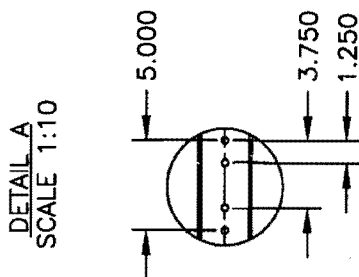
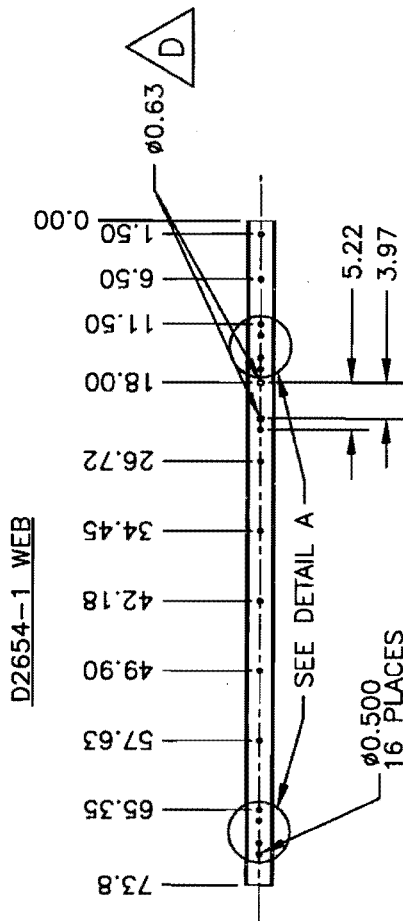
NOTE: Date & initial all entries

DART

DEO ATTACHED

RELEASED
04.06.22

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. E
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D2654	SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO Ø0.63			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	CP # 04.08.24	PER TOOLING; 80.8 WAS 80.5			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67675

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11-03-25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

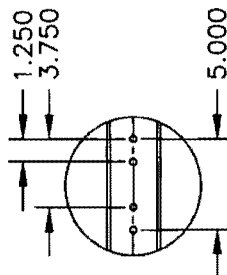


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

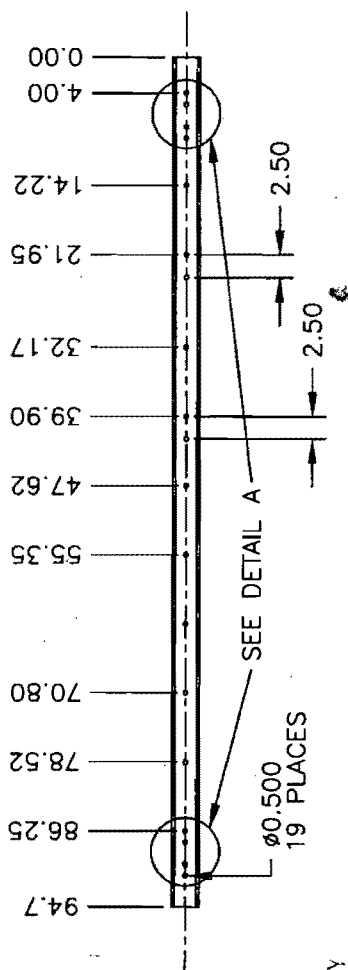
RELEASED
04.06.22

DEO ATTACHED

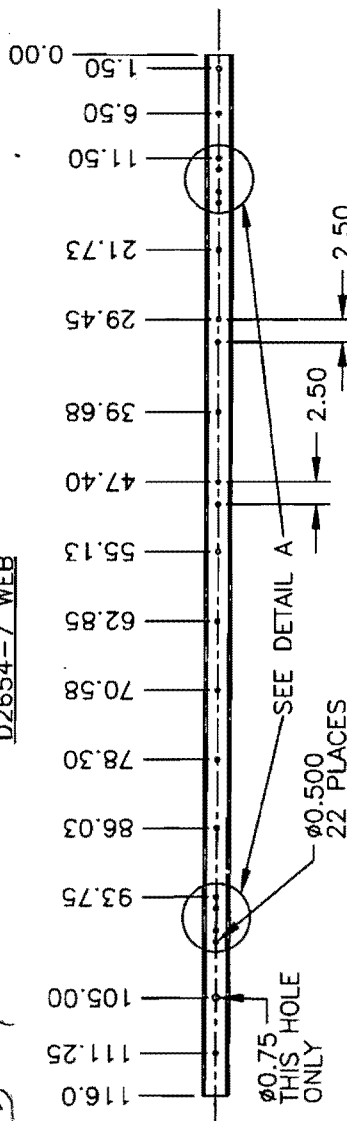
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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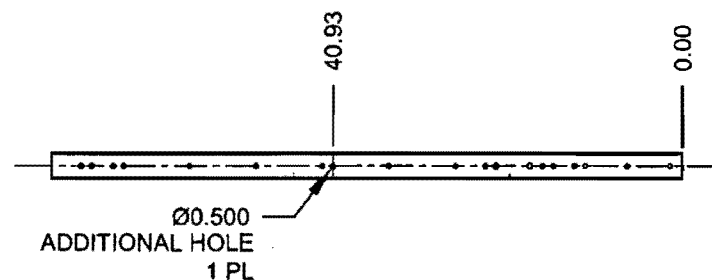
NOTE: Date & initial all entries

DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC	D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PT</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>	DE APPR. <i>H</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03		

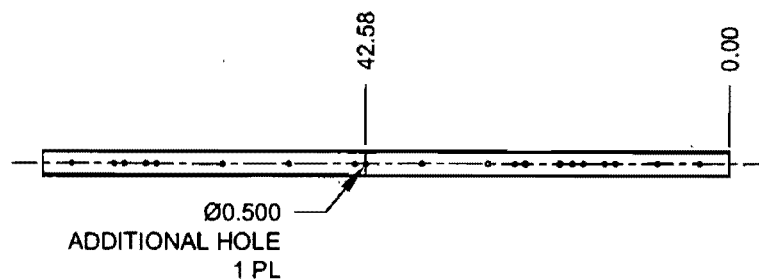
DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*

w/06/16/15



D2654-1 WEB



D2654-3 WEB

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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